

**Work Order ID 68312**

Page 1

Monday, April 11, 2011 1:30:31 PM

Item ID: D3186-2M

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACEPOD DOOR RH

Start Date: 4/11/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL Date: 11/04/11 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D3186

Rev E

100

0.00



PURCHASING

Purchasing

Memo

0.00

Issue P/O: 13844  
Description: D3186-2M Door

Supplier: Delastek

Conformity Certificate and Process sheet required

Ship 3 Items from Previous steps

CL 11/04/11 ①

110

0.00



Receive &amp; Inspect for Damage &amp; Mat'l Certs

Packaging

Memo

0.00

Ensure a copy of certification of conformity and process sheet from Delastek is attached.

Packaging ①

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

**Work Order ID 68312**

Monday, April 11, 2011 1:30:31 PM

Page 2

Item ID: D3186-2M

Accept

Setup Start

Revision ID:

Stop

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Start Date: 4/11/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

Check for void spot and pins.

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

(E)

11/10/17

11/10/17

ME 11-10-17

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Monday, April 11, 2011 1:30:27 PM

Page 1

Work Order ID: 68312

Parent Item: D3186-2M

Parent Item Name: SPACEPOD DOOR RH




Start Date: 4/11/2011

Required Date: 5/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 06-12-04 ec  
IPP rev D rv D dwg 07.03.07 ec

| Component Item ID/<br>Item Name  | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|--|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3186-2P<br><br>Spacepod Door |                        | Purchased     | No          |                     |                  | 110             | Each               | 0.0000         | 1           | 1            |               |                |        |



*PC 4/12/12 (1)*

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

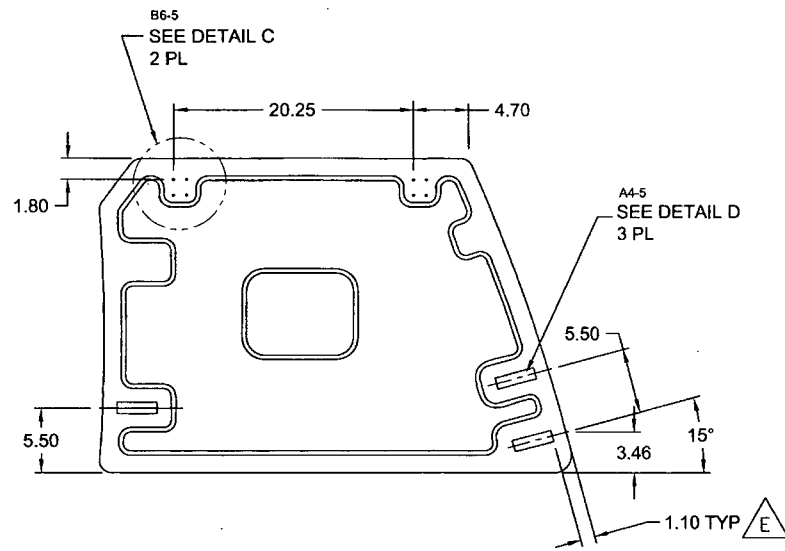
8 7 6 5 4 3 2 1

D

C

B

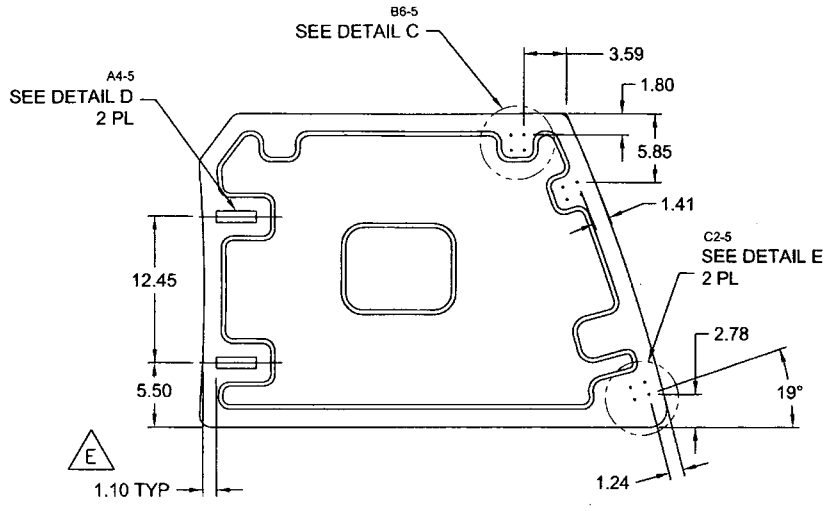
A



**D3186-1 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: N/A

0211104111  
W10.68312



**D3186-3 SPACEPOD DOOR, LH**  
MAKE FROM D3186-1M

**RELEASED**  
2009-09-09

|            |  |   |              |
|------------|--|---|--------------|
| REV.       | DESCRIPTION  | BY  | DATE         |
| E          | DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026 | RF  | 09.07.08     |
| D          | UPDATE DIMENSIONS  | LE  | 07.02.22     |
| C          | REMOVED D0600-XXX LABELS   | LE  | 06.12.13     |
| B          | DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN. UPDATED D3186-1M/2M/3/4 ADDED  | LE  | 06.09.25     |
| A          | NEW ISSUE  | CP  | 03.03.27     |
| DESIGN     | DS   | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | RF   |   |              |
| CHECKED    | JP   | DRAWING NO.   | REV. E       |
| MFG. APPR. | JP   | D3186   | SHEET 1 OF 5 |
| APPROVED   | JP   | TITLE   | SCALE        |
| DE APPR.   | JP   | SPACEPOD DOOR   | NTS          |
| DATE       | 09.07.08   | COPYRIGHT © 2003 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

8 7 6 5 4 3 2 1

**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

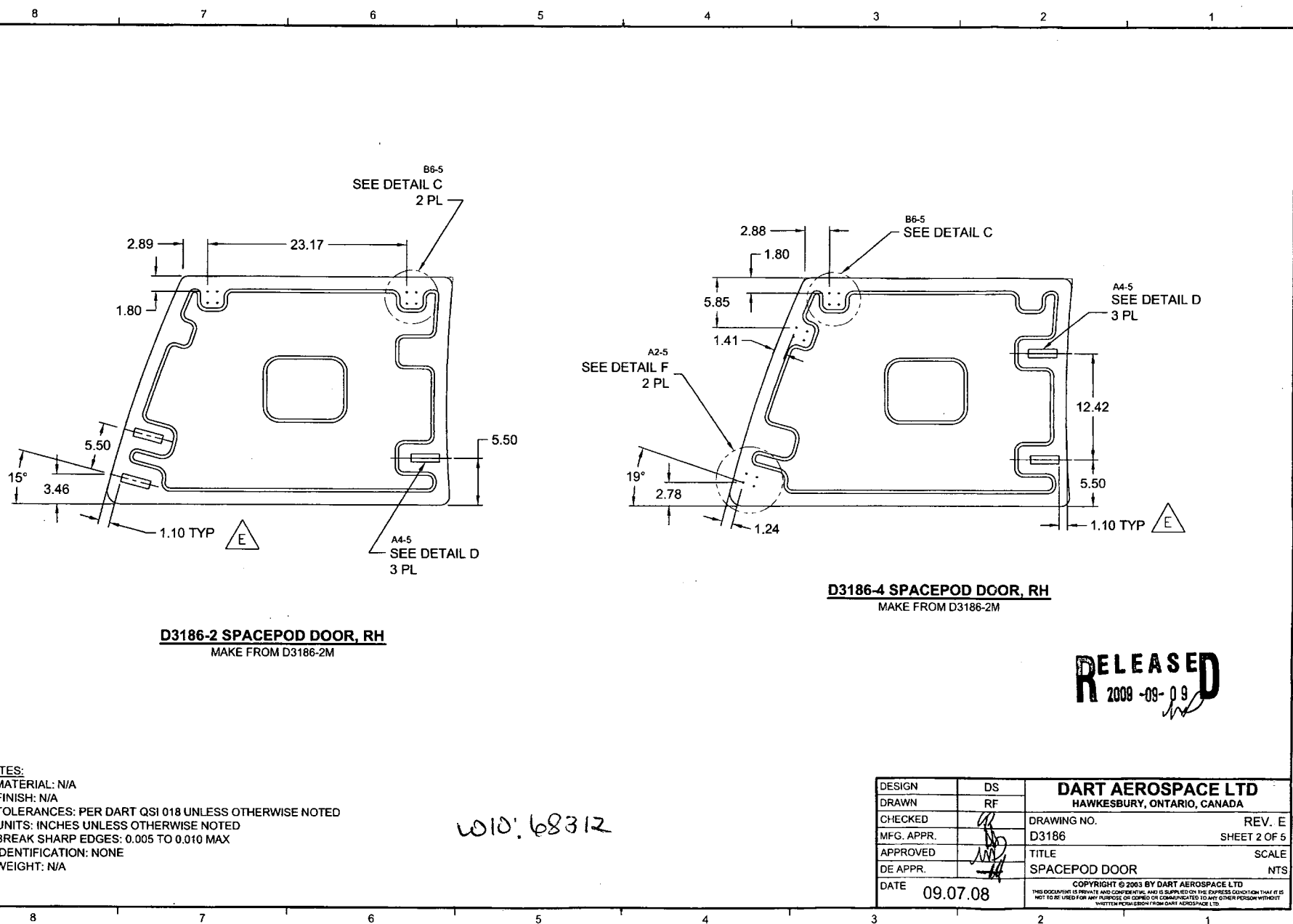
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

W10: 68312

|            |                    |   |              |
|------------|--------------------|---|--------------|
| DESIGN     | DS                 | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA  |              |
| DRAWN      | RF                 |   |              |
| CHECKED    | <i>[Signature]</i> | DRAWING NO.   | REV. E       |
| MFG. APPR. | <i>[Signature]</i> | D3186   | SHEET 2 OF 5 |
| APPROVED   | <i>[Signature]</i> | TITLE   | SCALE        |
| DE APPR.   | <i>[Signature]</i> | SPACEPOD DOOR   | NTS          |
| DATE       | 09.07.08           | COPYRIGHT © 2003 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS<br>NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT<br>WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

RELEASED  
2009-09-09

**Dart Aerospace Ltd**

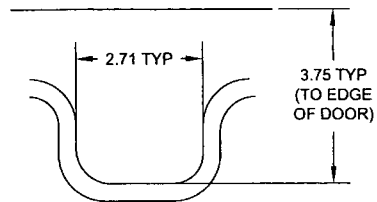
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

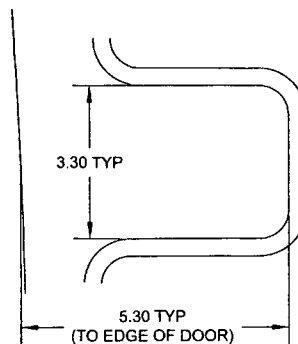
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

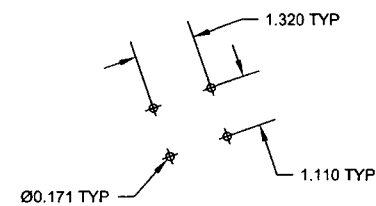
**NOTE:** Date & initial all entries



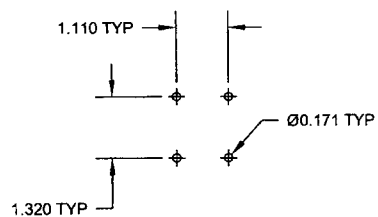
**DETAIL A** D6-3  
SCALE 4X D4-4



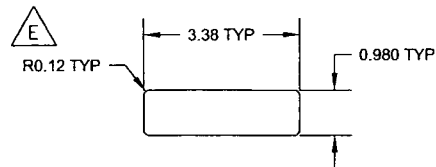
**DETAIL B** C6-3  
SCALE 4X C6-4



**DETAIL E** C1-1  
SCALE 4X

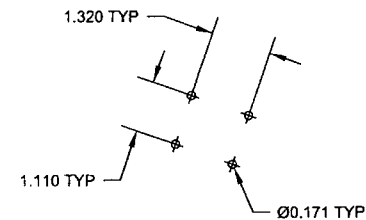


**DETAIL C** D7-1  
SCALE 4X D3-1  
D6-2  
D3-2



NOTE: ENSURE THAT CUTOUT IS PERPENDICULAR TO EDGE OF DOOR

**DETAIL D** C5-1  
SCALE 4X D4-1  
B6-2  
C2-2



**DETAIL F** C4-2  
SCALE 4X

**RELEASED**  
2009-09-09

WID:68312

|   |          |  |              |
|---|----------|--|--------------|
| DESIGN  | DS       | <b>DART AEROSPACE LTD</b>              |              |
| DRAWN   | RF       | HAWKESBURY, ONTARIO, CANADA            |              |
| CHECKED   | U        | DRAWING NO.                            | REV. E       |
| MFG. APPR.  | U        | D3186                                  | SHEET 5 OF 5 |
| APPROVED  | U        | TITLE                                  | SCALE        |
| DE APPR.  | U        | SPACEPOD DOOR                          | NTS          |
| DATE  | 09.07.08 | COPYRIGHT © 2003 BY DART AEROSPACE LTD |              |
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**Dart Aerospace Ltd**

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



Delastek inc.  
2699 5e avenue  
Local 14, Porte -A-  
Grand-Mère, Québec G9T 5K7  
Can \*\* Fax (819) 533-3494 \*\*

# PACKING SLIP CERTIFICATE OF COMPLIANCE

|            |         |
|------------|---------|
| Invoice #  | 40012   |
| Customer # | DART US |

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Ship to:

DART AEROSPACE LTD  
1270, Aberdeen Street  
Hawksbury, Ontario K6A 1K7  
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

| Ship via             |            | F.O.B.        |                | Terms   |           | Salesperson              |  |
|----------------------|------------|---------------|----------------|---|-----------|--------------------------|--|
| EPIC EXPRESS COLLECT |            | Origin        |                | Net 30 days USA   |           | Claude Lessard, ext. 233 |  |
| Ship date            | Order Date | Our PO #      | Order by       |   | Your PO # | GST/PST #                |  |
| 01/09/2011           | 11/04/2011 | 17297         | Chantal Lavoie |   | PO13846   |                          |  |
| Order Qty            | B.O. Qty   | Current Ship. | Item #         | Item Description  |           |                          |  |
| 1                    | 0          | 1             | DKC134-0060    | Line #4 N° D31862P Spacepod Door RH B68312 U de M : Each<br>Dwg. Rév.: E<br><br><u>No. série</u><br>B68312.<br><br><div><u>No. lot</u><br/>34889</div><br>J u / 10 / 12 |           |                          |  |

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:

Quality department



AQ-357

Mercredi, 2011-08-17 17:38:12

Utilisateur: Pascal Carignan

## Feuille de Procédé

|                        |                               |                 |                                |
|------------------------|-------------------------------|-----------------|--------------------------------|
| Client                 | : DART US DART AEROSPACE LTD  | Nom Dessin      | : SPACEPOD DOOR RH             |
| Numéro Job             | : 34889                       | Numéro Article  | : DKC134-0060                  |
| Numéro Soumission      | : 3769                        | Numéro Dessin   | : D3186                        |
| Numéro B.A.            | :                             | Projet Numéro   | : DK-359                       |
| Cette fois             | : 2011-08-17 No. B.V. :       | Révision dessin | : E                            |
| Prsht Rev.             | : NC                          | Matériel        | : 7781 & 411-350               |
| Prem. fois             | : - - Type :                  | Date Dûe        | : 2011-08-24 Qté: 1 UdM: UNITE |
| Job précédente         | : 34496                       |                 |                                |
| Écrit par              | : _____                       |                 |                                |
| Vérifié & Approuvé par | : _____                       |                 |                                |
| Commentaires           | : N° de pièce Client: D31862P |                 |                                |

**B 68312**

Process Sheet Rév.: 02 Modifier le N° de pièce D31862M pour  
D31862P, AAC1885 était AC0883, AAC1887 était AC0884.

## Produit additionnel

Numéro Job:



# Séq.: Machine ou Opération: Description :

1.0 AAC1616 N° 83634, Frekote Loctite Wolo

Commentair Qty.: 0.050 UNITE(s)/Unit Total: 0.050 UNITE(s)

N° 83634, Frekote Loctite Wolo

N° de Lot: \_\_\_\_\_

2.0 PRÉPARATION Préparation du moule



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation du moule N° DT 8006 selon IG 0009.

Date: \_\_\_\_\_ Sceau: \_\_\_\_\_

3.0 AAC1885 Tissu à délaminer Release ply B

Commentair Qty.: 3.28 VERGE(s)/Unit Total: 3.28 VERGE(s)

Tissu à délaminer Release ply B

# de Lot: \_\_\_\_\_

4.0 AAC1887 Wrightlon 5200 Bleu P3

Commentair Qty.: 3.59 VERGE(s)/Unit Total: 3.59 VERGE(s)

Wrightlon 5200 Bleu P3

# de Lot: \_\_\_\_\_

5.0 AC0885 Feutre de drainage N° Airweave N 10

Commentair Qty.: 3.00 VERGE(s)/Unit Total: 3.00 VERGE(s)

6.0 AC0943 Stretchlon 200 poche à vide Vert

Commentair Qty.: 3.00 VERGE(s)/Unit Total: 3.00 VERGE(s)

7.0 AMB0214 9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Commentair Qty.: 4.5 VERGE(s)/Unit Total: 4.5 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

N° de Lot: 1-31000-2

Date: Mercredi, 2011-08-17 17:38:12

Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 34889

Numéro Article: DKC134-0060

Numéro Job:



# Séq.: Machine ou Opération: Description :

8.0 AC0886 Ruban à gommer jaune #: T/AT-200Y

Commentair Qty.: 2.2500 ROULEAU(s)/Unit Total: 2.2500 ROULEAU(s)

9.0 AMB0349 Fiberglass 12 oz Unidirectional

Commentair Qty.: 1.00 VERGE(s)/Unit Total: 1.00 VERGE(s)

Fiberglass 12 oz Unidirectional

N° de Lot: 1-22549-1

10.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run: 0.5000Hrs

Tailler le matériel selon les différents patrons de découpe.

Appliquer le ruban jaune tout le tour du stretchlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps en les superposants les uns sur les autres.

Date: 22-08-11 Sceau:



11.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0080 GALLON(s)/Unit Total: 0.0080 GALLON(s)

Catalyst N° DDM-9

N° de Lot: 1-27829-1

12.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.500 LITRE(s)/Unit Total: 0.500 LITRE(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot: 1-31894-1

13.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run: 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 19/08/11 Sceau:



14.0 LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run: 0.2500Hrs

À l'aide d'un rouleau de 2" dia. appliquer une couche de résine sur le moule et ensuite imbiber un pli de tissu 9.7 oz.

Date: 19/08/11 Sceau:



Date: Mercredi, 2011-08-17 17:38:12  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 34889

Nom Dessin: SPACEPOD DOOR RH  
Numéro Article: DKC134-0060

Numéro Job:



# Séq.: Machine ou Opération: Description :

15.0 BAGGING Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laisser sécher pendant 4 heures minimum.

Heure début Curing: 1:20

Heure Fin Curing: 8:00h

Date: 19/08/11 sceau:



16.0 AMB0286 Catalyst N° DDM-9

Commentair Qty.: 0.0120 GALLON(s)/Unit Total : 0.0120 GALLON(s)

Catalyst N° DDM-9 N° de Lot: 1-27829-1

17.0 AMB0212 Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 0.300 LITRE(s)/Unit Total : 0.300 LITRE(s)

Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-31894-1

18.0 PREP-GENERAL Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine et imbiber toutes les surfaces du Foam Core selon IG0105.

Date: 22/08/11 Sceau:



19.0 DKC134-0057 Foam Core N° D3186-102 ( Porte D3186-2 )

Commentair Qty.: 1 UNITE(s)/Unit Total : 1 UNITE(s)

Foam Core N° D3186-102 ( Porte D3186-2 ) N° de Job: 34975

20.0 AAC1611 Polybond B46F

Commentair Qty.: 0.090 KIT(s)/Unit Total : 0.090 KIT(s)

Polybond B46F N° de Lot: 1-27795-1

21.0 ASSEMBLAGE Assemblage mécanique



Commentair Setup: 0.00Hrs/ Run: 15.0000Min Total Run : 0.2500Hrs

Retirez le bagging.

Pour aider au positionnement de 12 oz., positionner le gabarit de trimage dans le moule et tracer son contour sur le 9 oz. Retirez le gabarit de trimage.

Positionner le foam core à l'aide du gabarit prévu à cet effet et tracer le contour sur le 9 oz. ( Vous devriez maintenant avoir 2 contours de tracé sur le 9 oz. )



Date: Mercredi, 2011-08-17 17:38:13  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 34889

Nom Dessin: SPACEPOD DOOR RH  
Numéro Article: DKC134-0060

Numéro Job:



# Séq.: Machine ou Opération: Description :

Appliquer une couche de Polybond B64F à l'endos du Foam Core N° DKC134-0057 et positionner le foam Core sur le moule selon le dessin, et selon les lignes de positionnement prévues à cet effet.

Date: 23/08/11 Sceau:



22.0 BAGGING

Faire le bagging sur la pièce



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond.

Heure début Curing: 3:40

Heure Fin Curing: 4:50

Date: 23/08/11 sceau:



23.0 AMB0286

Catalyst N° DDM-9

Commentair Qty.: 0.0400 GALLON(s)/Unit Total : 0.0400 GALLON(s)  
Catalyst N° DDM-9 N° de Lot: 1-27829-1

24.0 AMB0212

Résine (411B7530) 411-350 promo. 75min.

Commentair Qty.: 1.000 LITRE(s)/Unit Total : 1.000 LITRE(s)  
Résine (411B7530) 411-350 promo. 75min N° de Lot: 1-31894-1

25.0 PREP-GENERAL

Préparation du matériel



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% catalyst par quantité de résine.

Date: 24/08/11 Sceau:



26.0 LAMINAGE

Faire le laminage



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage d'un pli de 12 oz. tout le tour de la porte.

Faire le laminage d'un pli de 9.7 oz.

Date: 24/08/11 Sceau:



Date: Mercredi, 2011-08-17 17:38:13  
Utilisateur: Pascal Carignan

## Feuille de Procédé

Client: DART US DART AEROSPACE LTD  
Numéro Job: 34889

Nom Dessin: SPACEPOD DOOR RH  
Numéro Article: DKC134-0060

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|      |         |                               |
|------|---------|-------------------------------|
| 27.0 | BAGGING | Faire le bagging sur la pièce |
|------|---------|-------------------------------|



Commentair Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 0.1667Hrs

Faire la poche à vide selon IG 0012.

Laissez Sécher 4 heures minimum

Heure début Curing: 12:45

Heure Fin Curing: 8:00

Date: 24/08/11 sceau:



|      |           |                       |
|------|-----------|-----------------------|
| 28.0 | DÉMOULAGE | Démoulage de la pièce |
|------|-----------|-----------------------|



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

Sabler la surfaces de la pièce qui était en contact avec le moule afin d'éliminer le fini lisse de celui-ci.

Date: 25-08-11 Sceau:



|      |         |         |
|------|---------|---------|
| 29.0 | TRIMAGE | Trimage |
|------|---------|---------|



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Trimer le contour de la pièce à l'aide du gabarit de trimage prévu à cet effet.

Date: 25-08-11 Sceau:



|      |         |                        |
|------|---------|------------------------|
| 30.0 | AAC1021 | Dupont Primer N° 7704S |
|------|---------|------------------------|

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot: 1-31117-3 = 1<sup>er</sup> côté et 2<sup>e</sup> côté

|      |         |   |
|------|---------|---|
| 31.0 | AAC1101 | N° 7775S, Dupont Activator - Reducer Chromabase |
|------|---------|---|

Commentair Qty.: 0.0283 UNITE(s)/Unit Total : 0.0283 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot: 1-31394-2 = 1<sup>er</sup> côté et 2<sup>e</sup> côté

|      |        |                    |
|------|--------|--------------------|
| 32.0 | PRIMER | Application primer |
|------|--------|--------------------|



Commentair Setup: 0.00Hrs/ Run: 30.0000Min Total Run : 0.5000Hrs

Appliquer une couche de primer selon IG 0008.

Date: 26 août Sceau:



# de fiche de mélange: N/A

ur: Pascal Carignan

# Feuille de Procédé

Client: DART US DART AEROSPACE LTD

Nom Dessin: SPACEPOD DOOR RH

Numéro Job: 34889

Numéro Article: DKC134-0060

Numéro Job:



| # Séq.: | Machine ou Opération: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|      |         |                                      |
|------|---------|--------------------------------------|
| 33.0 | AAC1492 | N° P-15-3, Adtech Micro Ultra Filler |
|------|---------|--------------------------------------|

Commentair Qty.: 0.010 GALLON(s)/Unit Total : 0.010 GALLON(s)

N° P-15-3, Adtech Micro Ultra Filler

N° de Lot:

1-31536-1

|      |          |                   |
|------|----------|-------------------|
| 34.0 | FINITION | Finition Générale |
|------|----------|-------------------|



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Faire les réparations de finition si nécessaire à l'aide du "Filler" P15-3.

Faire un léger sablage (Grit 220) de toutes les surfaces.

Date: 30/08/11

Sceau:



|      |         |                        |
|------|---------|------------------------|
| 35.0 | AAC1021 | Dupont Primer N° 7704S |
|------|---------|------------------------|

Commentair Qty.: 0.1400 UNITE(s)/Unit Total : 0.1400 UNITE(s)

Dupont Primer N° 7704S

N° de Lot:

1-31638-3

|      |         |   |
|------|---------|---|
| 36.0 | AAC1101 | N° 7775S, Dupont Activator - Reducer Chromabase |
|------|---------|---|

Commentair Qty.: 0.0300 UNITE(s)/Unit Total : 0.0300 UNITE(s)

N° 7775S, Dupont Activator - Reducer Chromabase

N° de Lot:

1-30548-3

|      |        |                    |
|------|--------|--------------------|
| 37.0 | PRIMER | Application primer |
|------|--------|--------------------|



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Appliquer une couche de primer selon IG 0008.

Date: 31/08/11

Sceau:



# de Fiche de mélange:

N/A) 2<sup>e</sup> côté  
N/A) 1<sup>er</sup> côté

|      |              |                   |
|------|--------------|-------------------|
| 38.0 | INSPEC FINAL | Inspection finale |
|------|--------------|-------------------|



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 0.0833Hrs

Faire l'inspection finale par la qualité selon le dessin.

Date: 01 SEP. 11

Sceau:



bb

|      |           |                         |
|------|-----------|-------------------------|
| 39.0 | EMBALLAGE | Emballage & Entreposage |
|------|-----------|-------------------------|



Commentair Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

Emballer et entreposer selon IG 0057

Date: 01 sept 11

Sceau:



JOB 34889